

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013690**Date Inspected:** 29-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Segment # 7BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at T-Ribs to T-Ribs at Segment Transverse Splice Side Panel (FL 3 Location) at Panel Point (PP) 50 to PP 52 for Segment 7BW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00334 Dated April 29, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220035 and final torque required was 433 N-m (Side Panel Cross Beam Side)

Manual Torque wrench was been used with Sr. No. XQ2-779.

Note: Numbering Bottom to Top T-Rib No. 11th, 12th, 15th, and 19th balance for bolts installed and tension verification Panel Point-50.

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Panel Point-51 T-Rib No. 12th balance for Bolts installed and tension verification.

Segment # 8CW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at T-Ribs to T-Ribs at Segment Transverse Splice Side Panel (FL 3 Location) at Panel Point (PP) 68 to PP 70 for Segment 8CW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00335 Dated April 29, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220035 and final torque required was 433 N-m (Side Panel Cross Beam Side)

Manual Torque wrench was been used with Sr. No. XQ2-779.

Segment # 8CW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 058087 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Counter Weight side, weld joint identified as CA053-004; The Critical Welding Repair Report (CWRR) was B-CWR1405. ZPMC QC is identified as Mr.Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM- Repair-1. See the attached below Photo.

Segment # 7BE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 066258 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Bike Path side, weld joint identified as CA042-004; The Critical Welding Repair Report (CWRR) was B-CWR1378. ZPMC QC is identified as Mr.Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM- Repair-1.

Segment# 7BW (DP647A)

This QA inspector observed, Heat Straightening Perform ZPM QC is identified as Mr.Zhang Qiang. The max Deformation is about 10mm.The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8369 Rev-0 Dated 2010-04-25.See the attached below Photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer